

# Work Order ID 61557

Monday, August 30, 2010 11:21:34 AM



Page 1

Item ID: D350-589-011

Accept



Setup Start



Revision ID:

Item Name: Side Door Latch Modification

Stop



Start Date: 8/30/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 9/6/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

*[Signature]*

Date: 10-8-30

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
INN-D350-589	E

100

0.00



DC

DOCUMENT CONTROL

Memo

0.00

Document Control

Photocopy blue file and type label as per PPP D350-589-011 CHG002

*S. Soler/29*

*10/9/28 BG 10-9-28*

105

0.00



Packaging

Pick Kit

Memo

0.00

Packaging

*10/9/28*

110

0.00



QC

QC4- 100% Inspect kits for completeness

Memo

0.00

Quality Control

*[Signature]*

*S. Soler/29*

*(X40)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 61557**

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Item ID: D350-589-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Side Door Latch Modification

Start Date: 8/30/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 9/6/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120

0.00



Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per QSI 014

MVF

10/29/29 (4)

130

0.00



QC21- Final Inspection - Work Order Release

QC

Memo

0.00

Quality Control

10/09/30  
MF  
10-9-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 61557

Parent Item: D350-589-011

Parent Item Name: Side Door Latch Modification

Start Date: 8/30/2010

Required Date: 9/6/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP F02.08.29 Removed D2587 Plug KJ  
ALL AT CHANGE 002

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN960JD10 Washer	NAS1149D0363J	Purchased	No			105	Each	6.0000	3	6 12x			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST				6					
					107715			6					
D2237 Striker Plate		Manufactured	No			105	Each	41.0000	3	6			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST009				41					
					58181			19					
					60492			22					
D2583 Latch Bracket		Manufactured	No			105	Each	20.0000	3	6			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST017				18					
					60497			18					
				ST018				2					
					56527			2					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 61557

Parent Item: D350-589-011

Parent Item Name: Side Door Latch Modification

Start Date: 8/30/2010

Required Date: 9/6/2010

Start Qty: 2.00

Required Qty: 2.00

D2585

Manufactured No

105 Each

55.0000

Mounting Channel

Location

Loc Qty

Loc Code

ST019

55

56524

1

59118

28

59873

26

D2586

Manufactured No

105 Each

38.0000

Door Latch

Location

Loc Qty

Loc Code

ST006

38

57917

38

D2587

Manufactured No

105 Each

24.0000

Door Slug, 350 Hinge

Location

Loc Qty

Loc Code

ST019

24

56555

24

D2589

Manufactured No

105 Each

185.0000

Keys, Key Chain, 350 Hinge

Location

Loc Qty

Loc Code

ST019

185

58194

185

3 6 12  
BSS313 10/9/2010

3 6 1  
BSS314 10/9/2010

1 2  
10/9/2010

1 2  
10/9/2010

6+6

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 61557

Parent Item: D350-589-011

Parent Item Name: Side Door Latch Modification

Start Date: 8/30/2010

Required Date: 9/6/2010

Start Qty: 2.00

Required Qty: 2.00

MS20470AD4-5

Purchased

No

105

Each

1,117.000

6

12



Rivet, Universal Head

## Location

## Loc Qty

## Loc Code

ST309

1052

114761

1052

ST319

65

111916

65

MS21042L3

Purchased

No

105

Each

2,176.000

3

6



Nut

## Location

## Loc Qty

## Loc Code

ST300

2176

114523

115

114718

61

114784

2000

MS27039-1-15

Purchased

No

105

Each

85.0000

3

6



Screw

## Location

## Loc Qty

## Loc Code

ST292

85

114056

2

114718

83

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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REFERENCE ONLY

## 52.4 PARTS LIST

589 -011	589 -041	589 -042	589 -043	Part Number	Description
X				D350-589-011	SIDE DOOR LATCH MODIFICATION KIT
	X			D350-589-041	SIDE DOOR ASSEMBLY, LH AS 350
		X		D350-589-042	SIDE DOOR ASSEMBLY, RH AS 350/355
			X	D355-589-043	SIDE DOOR ASSEMBLY, LH AS 355
	1			D2991-1	Door
		1		D2991-2	Door
			1	D2991-3	Door
3	3	3	3	D2237	Striker Plate
	1	1	1	D2464-1700	Seal
3				D2583	Latch Bracket
3	3	3	3	D2585	Latch Clamp
3	3	3	3	D2586	Latch
1				D2587	Plug
1	1	1	1	D2589	Keys, Key Chain
	3	3	3	D2621	Latch Plate
	2**	2**	2**	D2992-1	Doubler
	1	1	1	D3085-041	Prop Assembly
	1*	1*	1*	D3015-3	Locknut
	1*	1*	1*	D3081-1	Prop Hinge
	1*	1*	1*	D3082-1	Clip
	1*	1*	1*	D3084-1	Prop Arm
	1*	1*	1*	AN4-5A	Bolt
	3*	3*	3*	AN960JD10	Washer
	3*	3*	3*	AN960JD10L	Washer
	2*	2*	2*	AN960JD416	Washer
	1*	1*	1*	AN960JD516L	Washer
	3*	3*	3*	MS21042L3	Nut (or MS21042-3)
	1*	1*	1*	MS21042L4	Nut (or MS21042-4)
	3*	3*	3*	MS27039-1-13	Screw
	1*	1*	1*	SL69-BS	Ball Stud
	6	6	6	AN3-4A	Bolt
3	3	3	3	AN960JD10	Washer
3	9	9	9	MS21042L3	Nut (or MS21042-3)
6	6	6	6	MS20470AD4-5	Rivet
3	3	3	3	MS27039-1-15	Screw

\* Reference only. Included in D3085-041 Prop Assembly listed above.

\*\* Reference only. Included in D2991-1/-2/-3 Doors listed above.

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